

Date: Monday, 09/02/2009 4:24:42 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD BLADE FOLD ASSEMBLY
Job Number :	45641		
Estimate Number :	13531		
P.O. Number :		Part Number :	PB674300101
This Issue :	09/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1, 2
First Issue :	/ /	Project Number :	N/A
Previous Run :	45640	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	01/04/2009
Written By :		Qty:	2
		Um:	Each
Checked & Approved By :	<u>MF 09-04-06</u>		
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300107	Fwd Blade Fold Assembly Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Fwd Blade Fold Assembly Weldment
 batch: B45048

Pl 09-04-07

2.0	PB674300115	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Fwf Adjustable Blade Support Assembly
 batch: B45041

Pl 09-04-08

3.0	PB674300111	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Fwf Adjustable Blade Support Assembly
 batch: B45043

Pl 09-04-08

4.0	PB674300121	PB67-43001-21
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 PB67-43001-21
 batch: 45038

MF 09-04-06

5.0	PB674300123	PB67-43001-23
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 PB67-43001-23
 batch: B45035

MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:	Machine Or Operation:	Description :
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6.0	PB674300145	Longitudinal Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Support Assembly

batch: B 45028

MF 09-04-06

7.0	PB674300151	Long T-Handle Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Long T-Handle Assembly

batch: B 45026

MF 09-04-06

8.0	PB6743001261	Lever Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lever Arm

batch: B 44918

MF 09-04-06

9.0	PB6743001265	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

batch: B 44977

MF 09-04-06

10.0	PB6743001299	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: 43094

MF 09-04-06

11.0	D3451041	Handle and Lock-Down Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: 46082 x 1, B 45302 x 1

MF 09-04-06

12.0	D3451047	Handle and Lock-Down Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B 45310

MF 09-04-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45641

Part Number: PB674300101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D34473	Square Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Square Spacer

batch: 41351

MF 09-04-06

14.0	D34477	Clevis
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Comment: Q. 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clevis

batch: B46722 *

Finishing

pl 09-04-07

15.0	D34479	Swing Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Swing Arm

batch: m 39968

MF 09-04-06

16.0	D3445041	Belt Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Belt Assembly

batch: 41350

MF 09-04-06

17.0	086004	Inventory
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inventory

batch: m109350

MF 09-04-06

18.0	MS27039104	Inventory
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inventory

batch: m18431

MF 09-04-06

19.0	MS27039123	SCREW
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

batch: m108057

MF 09-04-06

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: m110399

MF 09-04-06

21.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

batch: m109282

MF 09-04-06

22.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: m108183

MF 09-04-06

23.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108986

m5518598-m108987

MF 09-04-06

24.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch:

or MS51859-7 (see engineering) batch: m110193

ENGINEERING
APPROVAL

MF 09-04-06

25.0

NAS43DD368

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: m109060 x 3, m110983

MF 09-04-06

26.0

NAS1149F0316P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m111124

MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45641

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: 18057

MF 09-04-06

28.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: 18057

MF 09-04-06

29.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: 18057

MF 09-04-06

30.0

AN960JD6

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: m6085

MF 09-04-06

31.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m107178

MF 09-04-06

32.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m110552

MF 09-04-06

33.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch:

or AN415A (see engineering) batch: m110399

09.04.09

ENGINEERING
APPROVAL

MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 45641

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: M05558

MF 09-04-06

35.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch:

or AN6116A (see engineering) batch: M111119

ENGINEERING
APPROVAL

MF 09-04-06

36.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: M110915

MF 09-04-06

37.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIVET

batch: M109119

MF 09-04-06

38.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

cherry rivet

batch: M104214

MF 09-04-06

39.0

MS17984C408

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIN, QUICK RELEASE

batch: M108473

or MS17984C410 (see engineering) batch:

ENGINEERING
APPROVAL

MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 45641

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIN, QUICK RELEASE

batch: m111219

MF 09-04-06

41.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

8" LANYARD

batch: m108973

MF 09-04-06

42.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

LANYARDS

batch: m111351

MF 09-04-06

43.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

SPRING SLOTTED PIN

batch: m111088

MF 09-04-06

44.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: m109687

(x2)

CP 09-04-09

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/09 (2)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P0045657

SS 09/04/13 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45641

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/13 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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